

Container No: S114688



Part: 647.7811

Job No: 181396

Serial No/Batch: S114688

Revision:

Inspector:

Exp Date:

Instructions:

Date: 09/29/18

) 632-5200
) 632-5246

Job Qty: 50 Ea

DAS

21

9-89

647.7811

Job Sheet 181396



Part Name: Bracket B



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev A: RQ 15.08.06 Verified by: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	Sign-off
90	Start up Operation	50 Ea	9/10/18		0.00	0.00	Start Up Machining-1		S.C 18/09/29
100	Bandsaw	50 pcs	9/10/18		0.00	2.32	Bandsaw1		S.C 18-09-29
110	CNC Vertical Machining	50 pcs	9/10/18		0.72	23.73	HAAS1-1		S.C 18-09-29
120	QC	50 pcs	9/10/18		0.00	0.00	QC2 Machining-1		S.C 18-09-29
130	QC	50 pcs	9/10/18		0.00	0.00	QC8 Machining-1		S.C 18-09-29
140	Outsource	50 pcs	9/10/18				ATG001-VC	P041337	OCT 15 2018
150	Packaging	50 pcs	9/10/18		0.00	0.00	Packaging2		NOV 07 2018
155	QC	50 pcs	9/10/18		0.00	0.00	QC5		NOV 09 2018
180	Packaging	50 pcs	9/10/18		0.00	0.00	Packaging3-1		NOV 09 2018
190	QC21-SA	50 Ea	9/10/18		0.00	0.00	QC21		NOV 12 2018

Part Op 100 - Cut Blank at 10.313"

Descriptions: 110 - 1-Machine per folio FB408

140 - Issue P/O to ATG : _____ Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S6.000X0.250	7075-T6S Sheet 6" Thick Plate X 0.25" Wide	42.9500 ft (.859 ea)	90-Start up Operation	5102371
		(.8647ea)		5114687

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S6.000X0.250	43	48	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket B	0.090inches ± 0.005	0.095 0.085	0.09	
2	Bracket B	45.000inches ± 0.500	45.500 44.500	450	
3	Bracket B	0.255inches ± 0.005	0.260 0.250	0.250	
4	Bracket B	9.810inches ± 0.010	9.820	9.810	

DQA: _____ Date: 2018-09-27**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: <u>18136</u> Part No. <u>647,7811</u> NCR No. _____	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Date: <u>18-09-27</u>	Step #: <u>110</u>	QTY Effective: <u>1</u>	MRB (QSI042) Approval <u>18-09-26</u>																																																																	
Description Work Order Deviation <u>Started wrong program# and drilled thru a bolt and it left a mark on piece..</u> <u>1 Piece was badly scratched (from stock)</u>		Disposition <u>Scrap and replaced.</u> <u>Scrap and replaced s.c</u> <u>18/09/29</u>		Completed By <u>[Signature]</u> <u>18-09-27</u> Lead hand / Supervisor Approval Verification <u>[Signature]</u> <u>18-09-26</u> QC / QA Coordinator Approval <u>[Signature]</u> <u>18-09-26</u>																																																																
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OTHER: _____																																																																				

			9.800	
5	Bracket B	0.260inches $\pm$ 0.100	0.360 0.160	Radius 0.260
6	Bracket B	29.900Degrees $\pm$ 0.500	30.400 29.400	Angle 29.9
7	Bracket B	3.671inches $\pm$ 0.005	3.676 3.666	3.671
8	Bracket B	16.900Degrees $\pm$ 0.500	17.400 16.400	Angle 16.9
9	Bracket B	9.463inches $\pm$ 0.005	9.468 9.458	9.463
10	Bracket B	100.000Degrees $\pm$ 0.500	100.500 99.500	Angle 100°
11	Bracket B	18.700Degrees $\pm$ 0.500	19.200 18.200	Angle 18.7
12	Bracket B	9.092inches $\pm$ 0.002	9.094 9.090	9.092
13	Bracket B	3.332inches $\pm$ 0.002	3.334 3.330	3.332
14	Bracket B	7.300inches $\pm$ 0.002	7.302 7.298	7.300
15	Bracket B	0.397inches $\pm$ 0.002	0.399 0.395	0.397
16	Bracket B	2.575inches $\pm$ 0.002	2.577 2.573	2.575
17	Bracket B	2.475inches $\pm$ 0.002	2.477 2.473	2.475
18	Bracket B	0.500inches $\pm$ 0.002	0.502 0.498	0.500
19	Bracket B	0.400inches $\pm$ 0.002	0.402 0.398	0.400

Plex 7/26/18 8:09 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041337**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

PO No: PO041337
PO Date: 10/12/18
Due Date: 11/9/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Belanger, NatashaPhone:

Attention: Lalande, Marc-Andre

Via: Ground

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	181931-A	644.4117	Bracket, Fwd Pivot 1-ISSUE P/O TO ATG: 2-Anodize Black -MPP-172 Section 2.1 -Hard Anodize IAW Mil- A-8625 Type 3 Class 2 3-Certification of Comformity is required 1-ISSUE P/O TO ATG: 2-Anodize Black -MPP-172 Section 2.1 -Hard Anodize IAW Mil- A-8625 Type 3 Class 2 3-Certification of Comformity is required	Firmed	-	11/9/18	1 pcs	0 pcs	1 pcs	\$8.10/pcs	\$8.10
3	181424	646.9713	Body Issue P/O to ATG : Anodize, Color Black, Prime as per Dwg 646.9700	Firmed	-	11/9/18	40 pcs	0 pcs	40 pcs	\$15.55/pcs	\$622.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041337**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	181396	647.7811	Bracket B Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed	-	11/9/18	50 pcs	0 pcs	50 pcs	\$15.55/pcs	\$777.50
					50 X	NOV 07 2018					
5	179152	646.3110	Channel Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3100	Firmed	-	11/9/18	11 pcs	0 pcs	11 pcs	\$11.70/pcs	\$128.70
					11 X	OCT 31 2018					
6	183653	RBE350A93-3302-02-1	Handle Issue P/O to ATG: ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3302-02-1 Rev. 11 Certificate of Conformity is required	Firmed	-	11/9/18	16 pcs	0 pcs	16 pcs	\$8.55/pcs	\$136.80
					16 X	OCT 31 2018					
7	176390	RBT18649-9-1	Top Plate Issue P/O to GROUPE ALTECH; PO ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant Certificate of Conformity is required	Firmed	-	11/9/18	8 pcs	0 pcs	8 pcs	\$6.30/pcs	\$50.40
					8 X	NOV 05 2018					
Grand Total:										\$1,723.50	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO041337

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/24/18 2:36 PM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916437

Date: 06-Nov-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 50 ea	Part: 647.7811 ✓ Rev: A BRACKET B Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4 mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0006" (1 - 2 mils) per drawing. Job: 23937 PO: PO041337 ✓ Line: 4		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>6/11/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

